

Thursday, August 05, 2010 10:11:18 AM



**Accept**

**Setup Start**

**Stop**



**Start Date:** 8/5/2010      **Start Qty:** 9.00

**Cust Item ID:**

**Required Date: 8/12/2010      Req'd Qty: 9.00**



**Customer:**

**Reference:**

Run Start



**Approvals:**                      **Process Plan:**

Date: 16-8-04

**Tooling:**

Date:


**Stop**



**QC:**

Date:

**SPC (Y/N):****Date:**

110		0.00
		
HAAS 1		0.00
HAAS CNC vertical machine #1	<b>Memo</b> MACHINE AS PER FOLIO FA869 AND DWG FOLIO REV: <u>4A</u> DWG REV: <u>A</u>	
	DEBURR	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 61062

Thursday, August 05, 2010 10:11:18 AM



Page 2

Item ID:	D4016-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Hinge Half, Base				Stop	
Start Date:	8/5/2010	Start Qty:	9.00			
Required Date:	8/12/2010	Req'd Qty:	9.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00 0.00				9	0		
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00				9	0		
160  Packaging Packaging	Identify as per dwg & Stock Location <u>WA</u> <u>Steve</u> Memo	0.00 0.00				10/8/10	0x2		sf

W/O:		WORK ORDER CHANGES					
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**Work Order ID 61062**


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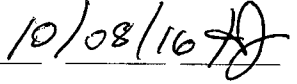


Page 3

Item ID: D4016-1 Accept  Setup Start   
Revision ID:  
Item Name: Hinge Half, Base Stop   
Start Date: 8/5/2010 Start Qty: 9.00  Cust Item ID:  
Required Date: 8/12/2010 Req'd Qty: 9.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

10/08/16   
MF  
10-8-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, August 05, 2010 10:11:22 AM

Page 1

Work Order ID: 61062



Parent Item: D4016-1



Parent Item Name: Hinge Half, Base


Start Date: 8/5/2010

Required Date: 8/12/2010

Start Qty: 9.00

Required Qty: 9.00

Comments: IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY :DD IPP Rev:B  
as per dwg REV.A DD 10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.500X1.500  304 bar 1.50 X1.50		Purchased	No			100	f	6.4704	0.08	0.757895			

Location

MAT54

108381

112752

Loc Qty

6.47040368

5.8123

0.65810368

Loc Code

75789

10/08/11

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	64062
<b>Description:</b> Hinge Half, Base		<b>Part Number:</b>	D4016-1
<b>Inspection Dwg:</b> D4016 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.875	+/-0.010	.878	—		Vern	ML-7
0.25	+/-0.030	.240	—		"	"
0.38	+0.030/-0.000	.394	—		"	"
R0.03	+/-0.030	R.030	—		R-G	
0.13	+/-0.030	.125	—		Vern	ML-7
0.88	+/-0.030	.877	—		"	"
Ø0.257	+0.006/-0.001	Ø.258	—		"	"
R0.38	+/-0.030	R.375	—		R-G	
0.500	+/-0.030	.500	—		Vern	ML-7
0.75	+/-0.030	.757	—		"	"

<b>Measured by:</b>	<i>[Signature]</i>	<b>Audited by:</b>	G.A	<b>Preliminary Approval:</b>	
<b>Date:</b>	10/08/14	<b>Date:</b>	10/08/15	<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ <i>[Signature]</i>	<i>[Signature]</i>

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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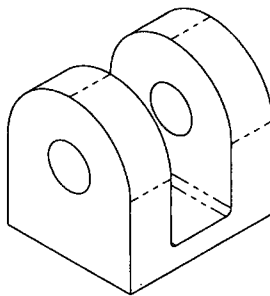
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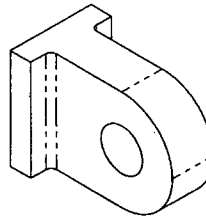
8 7 6 5 4 3 2 1

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER NO. 61062

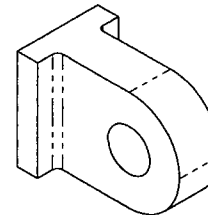
*BR10-805*



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID



D4016-5 HINGE HALF, LIGHT LID

**RELEASED**  
 2010-02-16  
*MP*

A NEW ISSUE		JPH	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4016	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET HINGE	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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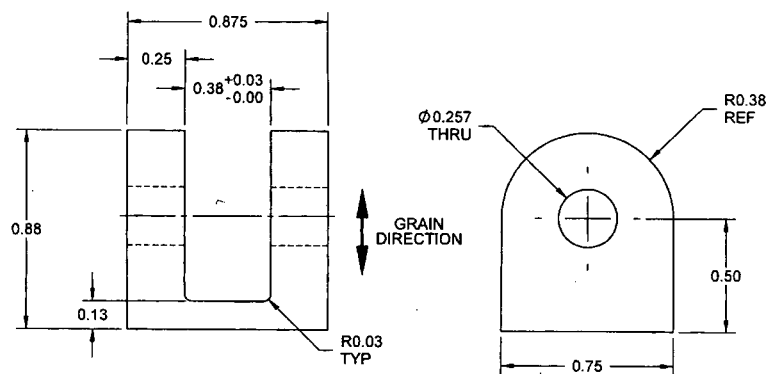
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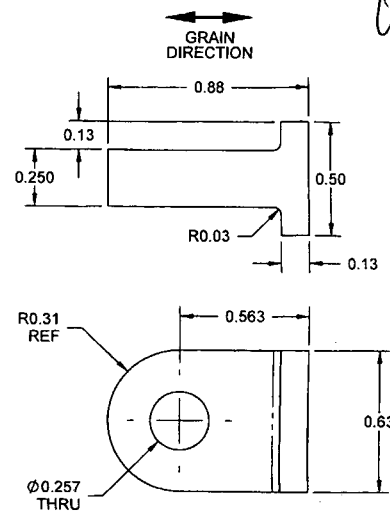
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**D4016-1 HINGE HALF, BASE**



**D4016-3 HINGE HALF, LID**

**D4016-5 HINGE HALF, LIGHT LID**

**NOTES:**

1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276  
REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX





6) IDENTIFICATION: NONE

7) WEIGHT -1: 0.09 lbs

-3: 0.04 lbs

-5: 0.01 lbs

**RELEASED**  
2010-02-16  
MD

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4016	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BASKET HINGE	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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